

Date: Tuesday, 1/31/2006 11:02:34 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : GHW MEDIUM BELL
Job Number : 25681	
Estimate Number : 12129	
P.O. Number : N/A	Part Number : D412729041
This Issue : 1/31/2006 S.O. No. : N/A	Drawing Number : DSK 092 REV B
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : LARGE FAB ASSY	Drawing Revision : B
Previous Run : 25680	Material : N/A
Written By : <u>[Signature]</u>	Due Date : 2/28/2006 Qty: 1 Um: Each
Checked & Approved By : <u>[Signature] 06.01.31</u>	
Comment : Est Rev:E 05.04.13 LPS3 rust inhibitor added; Hardware P/N's changed KJ/JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D27287	Decal
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2728-7 Label B22554

PCL 06.08.14

2.0	D3233041	Wheel Assembly
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D3233-041 Wheel Assembly B23577C

PCL 06.08.14

3.0	D32331	Inside Washer
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D3233-1 Inside Washer B23040

PCL 06.08.14

4.0	D32333	Outside Washer
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D3233-3 Outside Washer B23041

PCL 06.08.14

W/O:		WORK ORDER CHANGES					
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QA: N/C Closed: _____ Date: _____

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Job Number: 25681

Part Number: D412729041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D33091

Label



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3309-1 Label ~~B23767~~
B 22109

CPL 06.08.14

6.0

D33093

Label



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D3309-3 Label ~~B22109~~
B23768

CPL 06.08.14

7.0

D3330041

Frame Weldment



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3330-041 Frame Weldment B23016

CPL 06.08.14

8.0

D3331041

Handle Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3331-041 Handle Assembly B23568

CPL 06.08.14

9.0

D3332041

Pin Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3332-041 Long Pin Assembly B23770

CPL 06.08.14

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Job Number:



Seq. #:

Machine Or Operation:

Description :

10.0

D3332043

Pin Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3332-043 Short Pin Assembly

B23771

CPL 06.08.14

11.0

D33331

Base Plate Panel



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3333-1 Base Plate

B23055

CPL 06.08.14

12.0

D33333

Sliding Plate



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 ~~D3333-13 Base Plate~~

SLIDING-PLATE B25684

CPL 06.08.14

13.0

D33335

Rail



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number Description Batch

4 D3333-5 Rail

B23056

CPL 06.08.14

14.0

D33341

Wheel Shaft



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D3334-1 Wheel Shaft

B25685 ① B25686 ①

CPL 06.09.14

W/O:		WORK ORDER CHANGES					
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Job Number:



Seq. #:

Machine Or Operation:

Description :

15.0

D33351

Short Spring



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3335-1 Short Spring B22256

Ppl 06.08.14

16.0

D33353

Long Spring



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3335-3 Long Spring B22256

Ppl 06.08.14

17.0

D33361

Inventory



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3336-1 Jack B23772

Ppl 06.08.14

18.0

AN960JD416

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 AN960JD416 Washer 101369

Ppl 06.08.14

19.0

CP21

1/8" Cotter Pin 2" long



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 CP-21 1/8" Cotter Pin 2" long, Span M16301

Ppl 06.09.19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Job Number:



Seq. #:

Machine Or Operation:

Description :

20.0

HC12

1/4-20 UNC x 1" Hex Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 HC-12 1/4"-20 UNC x 1" long Hex Bolt, Span ~~M16626~~

NA 26ccdy done
on previous w/o
PCL 06-09-19

21.0

HC29

5/16-18 UNCx1.5 Hex Bolt



Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick:

Qty Part Number Description Batch

16 HC-29 5/16"-18 UNC x 1.5" long Hex Bolt, Prof M19705

PCL 06-08-14

22.0

HC153

3/8"-24UNFx1.25 Hex Bolt



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty Part Number Description Batch

8 HC-1533/8"-24 UNF x 1.25" long Hex Bolt, Span M16626

PCL 06-08-14

23.0

HN120

HEX SLOTTED NUT



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 HN-1201" Slotted Nut, Prof M18162

PCL 06-08-14

24.0

HN177

5/16-18UNC Nylon LockNut



Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick:

Qty Part Number Description Batch

16 HN-1775/16"-18 UNC Nylon Lock Nut, Span M16626

PCL 06-08-14

W/O:		WORK ORDER CHANGES					
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Job Number:



Seq. #:

Machine Or Operation:

Description :

25.0

HX15

1/4-20 UNCx3/4 S.H.C.S.



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 HX-15 1/4"-20 UNC x 3/4" long S.H.C.S., Span

M16626

✓

PCL 06.08.14

26.0

MS21042L5

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 MS21042L5 Nut (or -5)

M101648

✓

PCL 06.08.14

27.0

2333

1 1/4" Type B Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 2333 1 1/4" Type B Flat Washer (Wide), Span

M16154

✓

PCL 06.08.14

28.0

18SNB

3/8" Lock Washer



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty Part Number Description Batch

8 18-SNB3/8" Lock Washer, Span

M19705

✓

PCL 06.08.14

29.0

113803

1/8" PTF Grease Fitting



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 113-803 1/8" PTF Grease Fitting, Span

M19705

✓

PCL 06.08.14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: DD Date: 06/09/20
 QA: N/C Closed: _____ Date: _____

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Job Number:



Seq. #:

Machine Or Operation:

Description :

30.0

656036

Inventory



Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick:

Qty Part Number Description Batch

16 - 656-036 5/16" Type B Flat Washer (Narrow), Prof

M19624

~~656-036~~ 5/16 WC

31.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Cpl 06-09-19



Comment: LARGE FABRICATION RESOURCE 1

Assemble as per Dwg DSK 092. Apply LPS3 heavy duty rust inhibitor & corrosion (Procyon). Inflate wheel assembly to 90 psi. Ensure that unit goes up and down smoothly after assembly. Install decals last.

32.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

06-09-19

33.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

Inspection Level 21



06/09/20

Job Completion



U 06-09-20

W/O:		WORK ORDER CHANGES					
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



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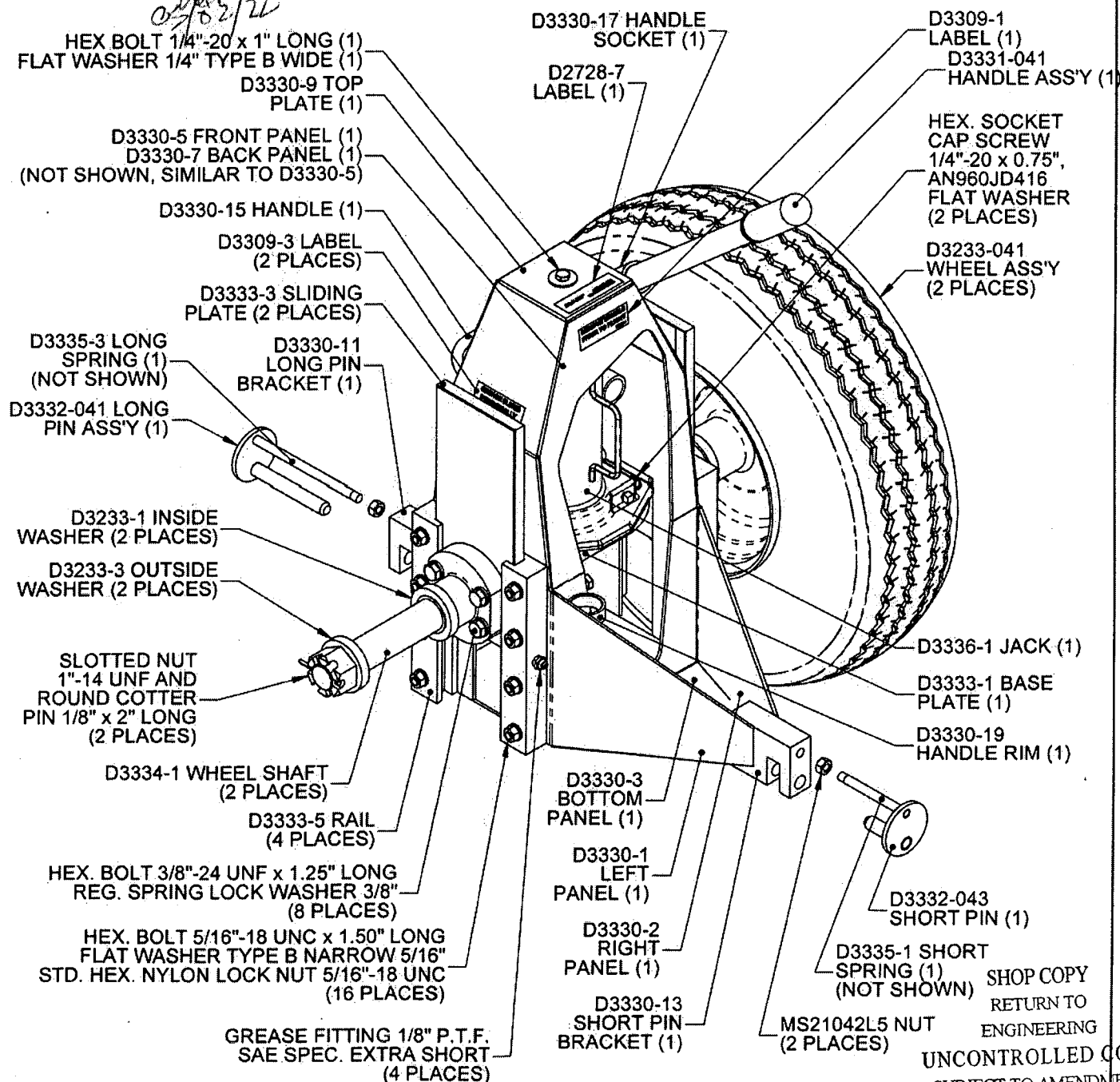
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DART

DESIGN 	DRAWN BY 	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 	APPROVED 	DRAWING NO. DSK 092	REV. B SHEET 1 OF 1
DATE 05.02.18		TITLE HYD. GROUND HANDLING	SCALE 1:5
A	04.12.06	NEW ISSUE	
B	05.02.18	REDESIGN TO FIT NEW WHEEL ASS'Y	

RELEASED

07/02/22**NOTE:**

- 1) APPLY RUST INHIBITOR ON ALL PARTS AND AREAS NOT PROTECTED BY PAINT OR GREASE.
RUST INHIBITOR POSSIBLE SUPPLIER: ACKLANDS-GRANGER INC., P/N LPSC30316.

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE

WORK ORDER

NO. **25681**

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